



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

order # 9582

S130075

RBW109-3130-69-101-3

Job Sheet 185274



Part No: RBW109-3130-69-101-3

Job Qty: 4 ea

Part Name: Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW109-3130-69-101 Rev.0 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-3		DAS 56 11-21
100	Mori Seiki	4 pcs	11/9/18	11/9/18	0.00	4.00	MORI SL2500Y		9-89 11-21
110	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-5		9-89 11-21
130	Mori Seiki	4 pcs	11/9/18	11/9/18	0.00	4.00	MORI NV5000-1	DELETE	45 2018-11-20
140	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		8-89 18-11-22
150	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		8-89 18-11-22
180	Outsource	4 pcs	11/9/18	11/9/18	0.00	0.00	Outsource4		8-89 18-11-22
190	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging2		NOV 27 2018
200	QC	4 pcs	11/9/18	11/9/18	0.00	0.00	QC6		9-89 38 NOV 27 2018
210	Packaging	4 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		DAS 9-89 NOV 27 2018
220	QC21-SA	4 Ea	11/9/18	11/9/18	0.00	0.00	QC21		21 NOV 27 2018

Part Op 100 - ***Cut blank at 3.15*** 1-Machine as per folio FC 451 FOLIO REV: 11-21 DWG REV: 0
Descriptions: 2-Deburr
130 - 1-Machine as per folio FC FOLIO REV: 11-21 DWG REV: 11-21 2-Deburr
150 - Engrave RBW109-3130-69-101 using MARKTRONIC engraver as per DWG. 45 11-21
180 - Issue P/O to GROUPE ALTECH; PO 041835 -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2
CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R5.000	6061-T6 Round Bar 5.000"	1.0520 ft (.263 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R5.000	1	9	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S130075



Part: RBW109-3130-69-101-3

Job No: 185274

Serial No/Batch: S130075

Revision: 0

Inspector:

Exp Date:

Instructions:

Date: 11/21/18

ns

be found.

Plex 10/24/18 12:37 PM Dart.lajeunesse.marie

BQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

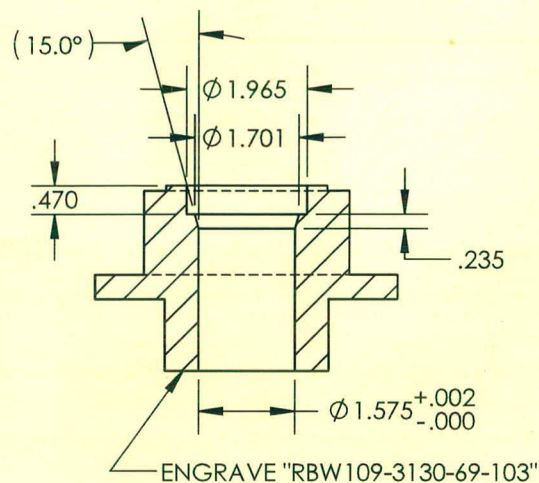
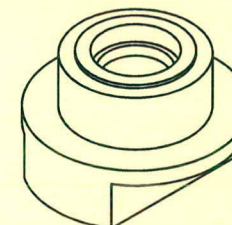
QA Closed: _____ Date: _____

Work Order update only ☐

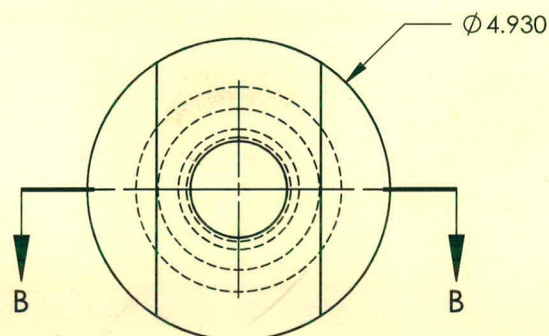
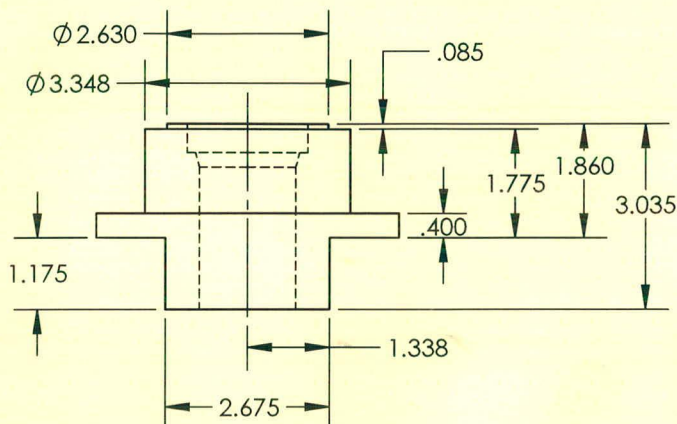
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



SECTION B-B



(-3)
BASE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185274MCS
1810-24

RED BARN MACHINE	
TITLE TAIL ROTOR PITCH CHANGE HOUSING, DUPLEX BEARING INSTL	
DWG NO. RBW109-3130-69-101-3	REV
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT CLEAR ANODIZE
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC MIL-A-8625F, TYPE II, CLASS I
SCALE 1:3	USED ON MODEL AW109
DATE 4/5/2011	SHEET 3 OF 3

1911

1911

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116

116

32



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041835**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041835
PO Date: 11/23/18
Due Date: 11/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185273	RBW109-3130-69-101-1	Pin -Issue P/O to ATG; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	11/27/18	3 pcs	0 pcs	3 pcs	\$3.83/pcs	\$11.49
2	185274	RBW109-3130-69-101-3	Base -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	11/27/18	5 pcs	0 pcs	5 pcs	\$3.83/pcs	\$19.15

5 X

NOV 27 2018

DAS
38
2-89

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Canada

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PURCHASE ORDER **PO041835**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	186016	649.4811	Clip Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL- PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	12/10/18	4 pcs	0 pcs	4 pcs	\$11.48/pcs	\$45.92
4	185603	D5583-1	Radius Block : Various STC's Issue P/O to ATG : 1- Anodize Black per MIL- A-8625, Type II, Class 2 as per Dwg. D5583 2- Prime Grey as per Dwg. Certification of Conformity is required.	Firmed	-	12/4/18	20 pcs	0 pcs	20 pcs	\$6.33/pcs	\$126.60
5	180672	RBW109- 3101-58-2- 3	Hammer Head -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	12/2/18	36 pcs	0 pcs	36 pcs	\$3.83/pcs	\$137.88
6		646.3711	Clip Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3700 Rev. A	Firmed	-	12/6/18	12 pcs	0 pcs	12 pcs	\$7.98/pcs	\$95.76
Grand Total:											\$436.80

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/27/18 1:15 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916625

Date: 27-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
5 ea	Part: RBW109-3130-69-101-3 Base Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils) Job: 24210	Rev: 4/5/2011 PO: PO041835 Line: 2	DAS 38 9-88
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>22/11/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

